

CLAIM AMENDMENTS

1 - 17. (canceled)

18. (currently amended) A method of making a fiber laminate, the method comprising the steps of sequentially:

forming a nonwoven spunbond filament layer of predetermined characteristics;

initially bonding the nonwoven spunbond filament layer in a calender comprising calender rolls by varying contact pressure and/or surface temperature of the calender rolls to obtain a nonwoven spunbond filament layer having varying degrees of bonding, measuring tensile strength of the nonwoven spunbond filament layer having varying degrees of bonding to obtain varying tensile strengths, and determining highest tensile strength from the varying tensile strengths, the nonwoven spunbond filament layer having the highest tensile strength being the nonwoven spunbond filament layer at maximum bonding ~~determining by the use of a pair of calender rolls a high tensile strength capacity of the spunbond nonwoven fabric at maximum prebonding of the fabric with varying contact pressure or surface temperature of the calender rolls such that the maximum and highest possible tensile strength capacity is derived for the spunbond nonwoven fabric;~~

thereafter prebonding the nonwoven spunbond filament layer to a tensile strength of at least 50% of the tensile strength

22 thereof at maximum bonding under conditions that are otherwise the
23 same as in the step of initially bonding the nonwoven spunbond
24 filament layer ~~as defined in DIN 53815~~ by adjusting the contact
25 pressure and/or the surface temperature of the calender rolls to
26 form a prebonded nonwoven spunbond filament layer;

27 treating the prebonded nonwoven spunbond filament layer
28 with at least one wetting agent;

29 applying at least one layer of hydrophilic fibers onto
30 the prebonded nonwoven spunbond filament layer treated with the
31 wetting agent; and

32 hydrodynamically bonding the layer of hydrophilic fibers
33 to the spunbond filament layer to create a two-layer laminate
34 forming an absorbent cloth.

19. (canceled)

1 20. (currently amended) The method defined in claim
2 ~~[[19]] 18 wherein the nonwoven spunbond filament layer is prebonded~~
3 ~~in step b) in a calender having has at least one heated embossing~~
4 ~~drum cylinder.~~

1 21. (currently amended) The method defined in claim 20
2 wherein the prebonding is carried out ~~in step b)~~ such that a
3 maximum free filament length between two bonding points of the
4 nonwoven spunbond layer is less than 15 mm.

1 22. (previously presented) The method defined in claim
2 21, further comprising the step of
3 additionally deforming the prebonded nonwoven spunbond
4 filament layer to increase the thickness thereof.

1 23. (previously presented) The method defined in claim
2 22 wherein the hydrophilic fibers are applied by at least one
3 carding machine or at least one air-layering device onto the
4 prebonded nonwoven spunbond filament layer.

1 24. (previously presented) The method defined in claim
2 23, further comprising the step of
3 applying a second spunbond nonwoven material onto the
4 laminate formed by the layers.

1 25. (previously presented) The method defined in claim
2 24 wherein the hydrodynamic bonding of the layers into the laminate
3 is effected by a water-jet treatment thereof.

1 26. (currently amended) The method defined in claim 18
2 wherein the prebonding is carried out ~~in step b)~~ such that a
3 maximum free filament length between two bonding points of the
4 nonwoven spunbond layer is less than 15 mm.

1 27. (previously presented) The method defined in claim
2 18, further comprising the step of
3 additionally deforming the prebonded nonwoven spunbond
4 filament layer to increase the thickness thereof.

1 28. (previously presented) The method defined in claim
2 18 wherein the wetting agent is at least one tenside or surface
3 active agent.

1 29. (previously presented) The method defined in claim
2 18 wherein the hydrophilic fibers are applied by at least one
3 carding machine or at least one air-layering device onto the
4 prebonded nonwoven spunbond filament layer.

1 30. (previously presented) The method defined in claim
2 18, further comprising the step of applying a second spunbond
3 nonwoven material onto the laminate formed by the layers.

1 31. (previously presented) The method defined in claim
2 18 wherein the hydrodynamic bonding of the layers into the laminate
3 is effected by a water-jet treatment thereof.

32 - 34. (canceled)